

Work Order ID 131761

Tuesday, April 21, 2015 1:49:23 PM

131761

Page 1

Item ID: D2654-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: ***NS2*** Stop
Item Name: Web
Start Date: 4/20/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2654	F

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

1-Cut D2600-7 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

2 0 15-5-28 DOL

DAS
18
9-00

2 0 15-05-28

2 0 15-6-1 DBC

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																													
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Page 2

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Revision ID: Stop ***NS2***
Item Name: Web
Start Date: 4/20/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 2.00 ***2*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-89
130	QC7-Inspect Chemical Conversion Coat	0.00								
130										
QC	Memo	0.00				2	0	15-06-01		
Quality Control										
140	Identify as per dwg & Stock Location: <u>46 002</u>	0.00								
140										
Packaging	Memo	0.00				2	0	15-6-1	DGC	
Packaging										
150	QC21- Final Inspection - Work Order Release	0.00								
150										
QC	Memo	0.00							15/6/12	
Quality Control										

(Handwritten signature/initials)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 131761

131761

Parent Item: D2654-5

D2654-5

Parent Item Name: Web

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-140		Manufactured	No			100	Each	0.0000	1	2			

D2600-7-140

EXT. "I BEAM" THICK

131525 x 2 15-5-28
DGL

DQA: _____ Date: _____

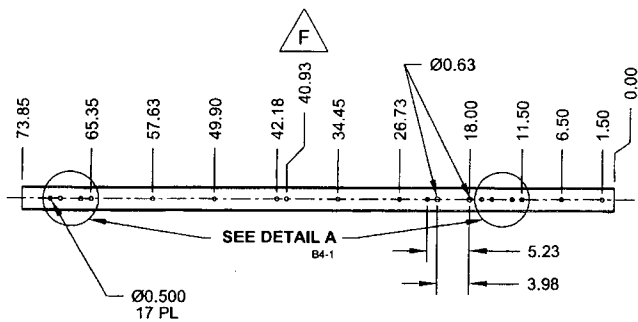


WORK ORDER NON-CONFORMANCE / UPDATE

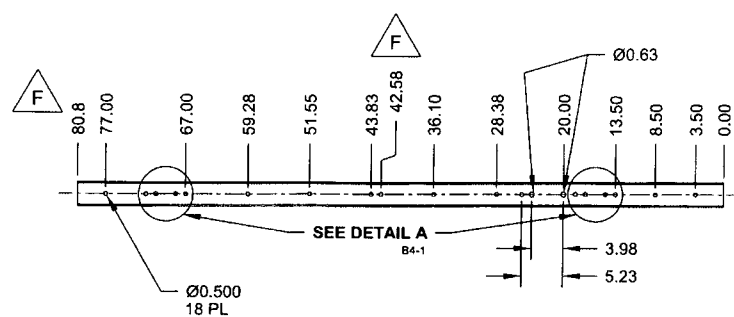
QA Closed: _____ Date: _____

Work Order update only ☐

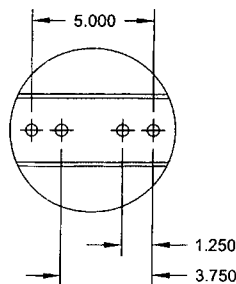
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D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C4-1
C5-1
C6-1
D3-2
D6-2
B3-2
B6-2

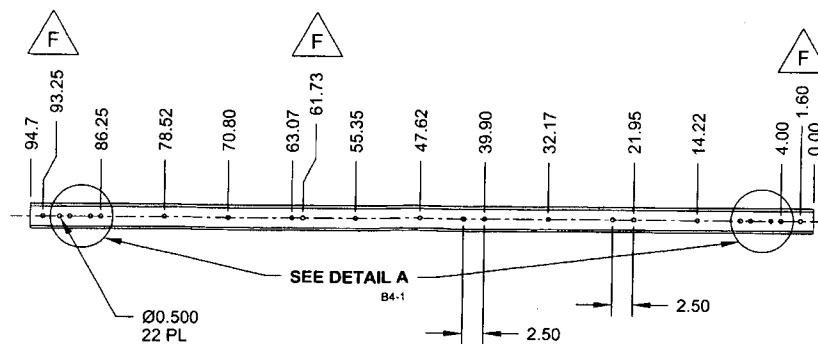
RELEASED
2011-09-12

NOTES:

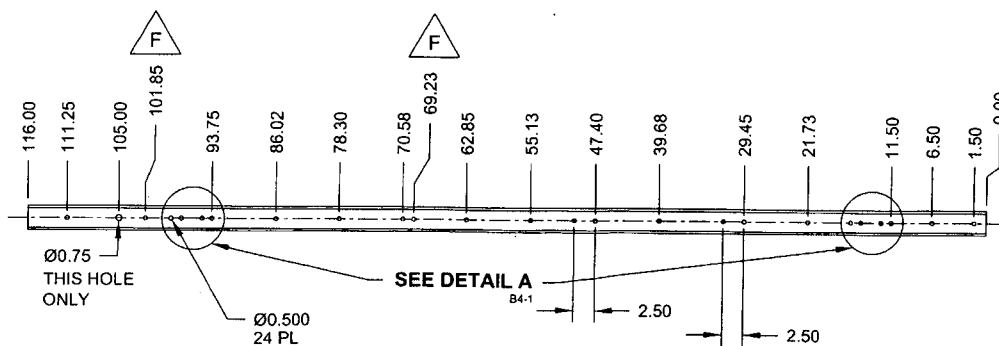
- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2		SC	11.05.05
E	CHANGE LENGTHS, REFORMAT		CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63		CP	98.01.15
C	CHANGED HOLE PATTERN		CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438		CP	97.06.26
A	NEW ISSUE		CP	97.03.25
REV.		DESCRIPTION		BY DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	SC			
CHECKED	<i>JP</i>	DRAWING NO.	REV. F	
MFG. APPR.	<i>JP</i>	D2654	SHEET 1 OF 2	
APPROVED	<i>JP</i>	TITLE	SCALE	
DE APPR.	<i>JP</i>	WEB	NTS	
DATE	11.05.05 COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

UNCL
SUBMIT
NO 131761 MCL
1504-22



D2654-5 WEB



D2654-7 WEB

RELEASED
2011-09-12
NW

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. F
MFG. APPR.	JE	D2654	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	